

Date: Thursday, 07/08/2008 12:58:47 PM
User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd. Drawing Name : D412-742-013
Job Number : 41047
Estimate Number : 10804
P.O. Number :
This Issue : 07/08/2008 S.O. No. :
Prsht Rev. : NC Part Number : D412742013
First Issue : / / Type : LANDING GEAR Drawing Number : DSI 9369/ECN08-510
Previous Run : 41046 Project Number :
Drawing Revision :
Material :
Due Date : 14/08/2008 Qty: 1 Um: Each
Written By :
Checked & Approved By :
Comment :

Additional Product

DART		TEL: 1-613-632-3336 FAX: 1-613-632-4443	
TRANSPORT CANADA APPROVAL 4-09-99			
P/N	D412-742-013	CHG	CHG004
DESC	Float Skidtube	STC	SR01583SE
LOT	B35744	STC	SH05-37
MODEL	205/210/212/412/AB412	STC	
US PATENT 6,573,518 CANADA FOREIGN PATENTS PENDING		MADE IN CANADA	

Job Number:



Seq. #:

Machine Or Operation:

Description

1.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

REMOVE FROM STK

D412-742-013 B

35744

2.0

D412742013

Float Skidtube Installation



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Float Skidtube Instln

3.0

HAND FINISHING 1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

REMOVE END CAPS BOTH ENDS

TO REMOVE/CLEAN LPS FROM TUBE

FOWARD TUBE TO SKIDTUBE CELL

FD 08/08/08 ①

4.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

A) - DRILL 0.500 DIAM. HOLES THRU D3391-021 FWD TUBE AND D3391-023 MID TUBE(2 PLACES) AS SHOWN ON DSI 9364.

INSTALL D3591-1 BUSHING B

31514

B) - DEBURR ALL HOLES

- TOUCH UP ALODINE

- TOUCH UP PAINT

C) - RECOAT WITH LPS3 B

106096

- FD 08/08/11 ①

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
08/08/11	4.0 (c)	- AN3C4A (6x) - AN960C-10L (x6) - D3672-1 (x6) - Put new bolts and washers to install caps on both ends.	FL	08/08/11				
08/08/11	4.0 (c)	- Aft cap D2646 was scrapped and replaced - New cap B37377	FL	08/08/11				

Part No: D412-742-013 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 11 Date: 08.08.21
 QA: N/C Closed: D Date: 08/29/26

NCR: <u>41047</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/08/11	4.0 (c)	- Aft cap D2646 was scrapped and replaced with new one. B37377 Damage after Disassembly		Scrap and Destroy and Replace with B# 37377	FL 08/08/11	S 08/08/11		S 08/10/13

NOTE: Date & initial all entries

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Drawing Name: D412-742-013

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Part Number: D412742013

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D35911

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
BUSHING

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
REINSPECT KIT FOR 100% COMPLETENESS

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
REPACKAGE PER PPP USING NEW B/N.
NEW PAPERWORK & LABELS REQ'D
CHG 005
-ENSURE DSI PAPERWORK ADDED

JLD 08.8.13

Rev E

8/8/19

50

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/2019

Job Completion



MF 08-08-19

35744

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DESIGN PH	DRAWN BY AJS	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED	DRAWING NO. DSI 9364	REV. C SHEET 1 OF 1
DATE 08.08.06	TITLE BUSHING INSTALLATION		SCALE NTS
A	07.01.16	NEW ISSUE	
B	07.03.20	ADD TOLERANCE TO 1/2" HOLE	
C	08.08.06	ADDED CHG 005 & SUBS TO EFFECTIVITY. TOLERANCE ON 1/2" HOLES WAS +0.006 -0.000	

REFERENCE ONLY

DART SERVICE INSTRUCTION

TO AMEND IIN-D412-742 REV. B AND ICA-D412-742 REV. 1

REF. FAA STC: SR01583SE

REF. CANADIAN STC: SH05-37 ISSUE 1

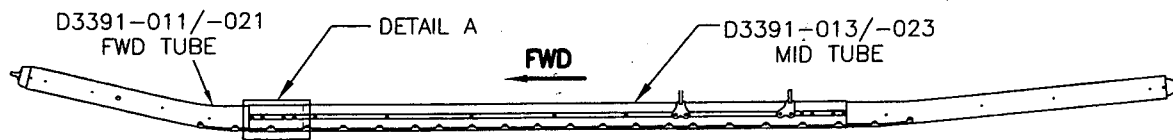
TO PREVENT THE D3391-011/-021 FWD TUBE FROM MOVING WITH RESPECT TO THE D3391-013/-023 MID TUBE, CUSTOMERS RECEIVING D412-742-011/-013 SKIDTUBES AT CHG 002 OR CHG 005 AND SUBSEQUENTS HAVE A D3591-1 BUSHING INSTALLED AT THE FWD SADDLE HOLES AS SHOWN IN DETAIL A (2 PLACES).

CUSTOMERS WITH D412-742-011/-013 SKIDTUBES AT CHG 001, CHG 003 AND CHG 004 CAN PROCURE THE DSI 9364-011 KIT AND INSTALL THE D3591-1 BUSHINGS AS FOLLOWS:

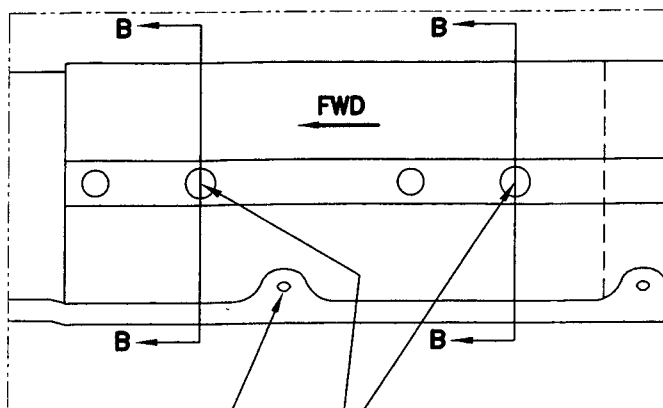
- 1) REMOVE SKIDTUBE/SADDLES FROM AIRCRAFT USING SECTION 32.7 OF ICA-D412-742 AS A GUIDELINE.
- 2) TRANSFER DRILL 1/2" HOLES ($\varnothing 0.500 \pm \begin{smallmatrix} 0.002 \\ 0.000 \end{smallmatrix}$) INTO THE FWD SADDLE HOLES AT THE LOCATIONS SHOWN (2 PLACES) THRU THE D3391-013/-023 MID TUBE AND D3391-011/-021 FWD TUBE. **DO NOT OPEN UP HOLES IN D2571/D2572 FWD SADDLES.**
- 3) REMOVE FWD TUBE FROM MID TUBE, DEBURR DRILLED HOLES, TOUCH UP HOLES WITH MIL-P-85582 OR MIL-P-23377 PRIMER
- 4) RE-INSTALL D3391-011/-021 FWD TUBE INTO D3391-013/-023 MID TUBE USING SECTION 32.7 OF ICA-D412-742 AS A GUIDELINE EXCEPT INSTALL D3591-1 BUSHINGS AS SHOWN IN DETAIL A USING LPS LABORATORIES LPS-3 CORROSION INHIBITOR PRIOR TO INSTALLING THE D2571/D2572 SADDLES.

QTY -011	PART NUMBER	DESCRIPTION
X	DSI 9364-011	BUSHING INSTALLATION
2	D3591-1	BUSHING

REFERENCE ONLY



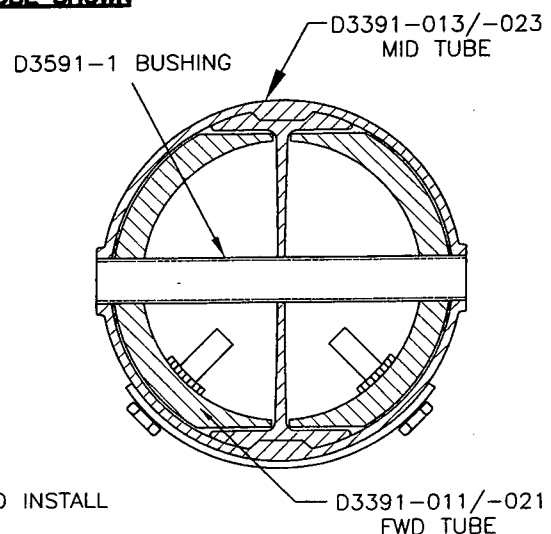
D412-742-011/-013 SKIDTUBE SHOWN



ENSURE BOLT IS FASTENED PRIOR TO TRANSFER DRILLING (REF)

OPEN TO $\varnothing 0.500 \pm \begin{smallmatrix} 0.006 \\ 0.000 \end{smallmatrix}$ AND INSTALL D3591-1 BUSHING (2 PLACES)

DETAIL A: D3591-1 BUSHING INSTALLATION LOCATION



SECTION B-B

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector


Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

DESIGN PH	DRAWN BY AJS	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 	APPROVED	DRAWING NO. DSI 9364	REV. C SHEET 1 OF 1
DATE 08.08.06	TITLE BUSHING INSTALLATION		SCALE NTS
A	07.01.16	NEW ISSUE	
B	07.03.20	ADD TOLERANCE TO 1/2" HOLE	
C	08.08.06	ADDED CHG 005 & SUBS TO EFFECTIVITY	

REFERENCE ONLY

DART SERVICE INSTRUCTION

TO AMEND IIN-D412-742 REV. D AND ICA-D412-742 REV. 3

REF. FAA STC: SR01583SE

REF. CANADIAN STC: SH05-37 ISSUE 1

REF EASA STC: IM.R.S.01126

TO PREVENT THE D3391-011/-021 FWD TUBE FROM MOVING WITH RESPECT TO THE D3391-013/-023 MID TUBE, CUSTOMERS RECEIVING D412-742-011/-013 SKIDTUBES AT CHG 002 OR CHG 005 AND SUBSEQUENTS HAVE A D3591-1 BUSHING INSTALLED AT THE FWD SADDLE HOLES AS SHOWN IN DETAIL A (2 PLACES).

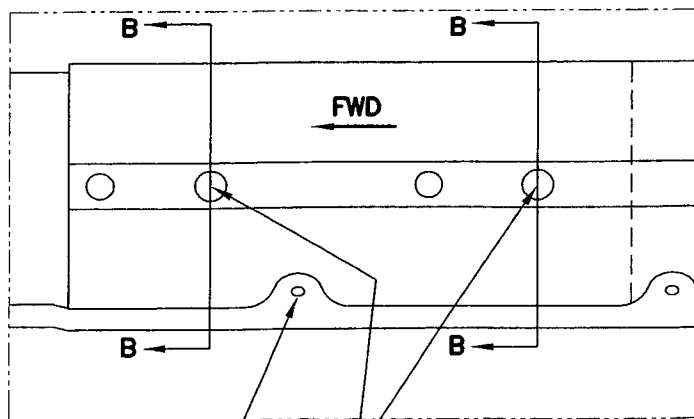
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- 1) REMOVE SKIDTUBE/SADDLES FROM AIRCRAFT USING SECTION 32.7 OF ICA-D412-742 AS A GUIDELINE.
- 2) TRANSFER DRILL 1/2" HOLES ($\varnothing 0.500 \pm \begin{smallmatrix} 0.006 \\ 0.000 \end{smallmatrix}$) INTO THE FWD SADDLE HOLES AT THE LOCATIONS SHOWN (2 PLACES) THRU THE D3391-013/-023 MID TUBE AND D3391-011/-021 FWD TUBE. **DO NOT OPEN UP HOLES IN D2571/D2572 FWD SADDLES.**
- 3) REMOVE FWD TUBE FROM MID TUBE, DEBURR DRILLED HOLES, TOUCH UP HOLES WITH MIL-P-85582 OR MIL-P-23377 PRIMER
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QTY -011	PART NUMBER	DESCRIPTION
X	DSI 9364-011	BUSHING INSTALLATION
2	D3591-1	BUSHING



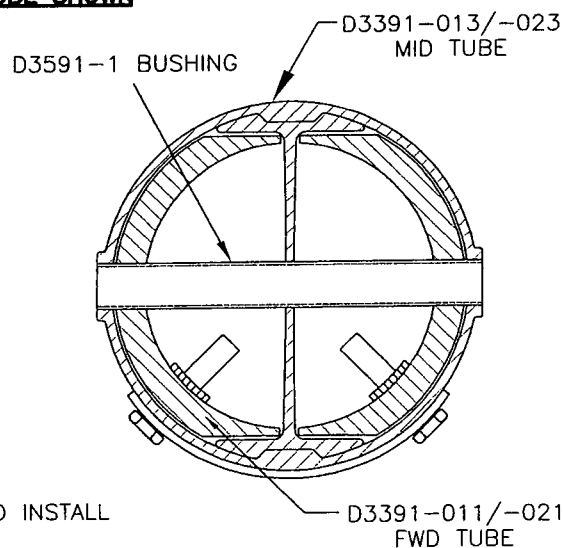
D412-742-011/-013 SKIDTUBE SHOWN



ENSURE BOLT IS FASTENED PRIOR TO TRANSFER DRILLING (REF)

OPEN TO $\varnothing 0.500 \pm \begin{smallmatrix} 0.006 \\ 0.000 \end{smallmatrix}$ AND INSTALL D3591-1 BUSHING (2 PLACES)

DETAIL A: D3591-1 BUSHING INSTALLATION LOCATION



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